CLAIM AMENDMENTS

1 – 17.   (canceled)

1   18.   (currently amended)   A method of making a fiber
2   laminate, the method comprising the steps of sequentially: [[a)]]
3   forming a nonwoven spunbond filament layer of
4   predetermined characteristics;
5   determining by the use of a pair of calender rolls a high
6   tensile strength capacity of the spunbond nonwoven fabric at
7   maximum prebonding of the fabric with varying contact pressure or
8   surface temperature of the calender rolls such that the maximum and
9   highest possible tensile strength capacity is derived for the
10   spunbond nonwoven fabric; [[b)]]
11   thereafter prebonding the nonwoven spunbond filament
12   layer to a tensile strength of at least 50% of the tensile strength
13   thereof at maximum bonding as defined in DIN 53815 by adjusting the
14   contact pressure or the surface temperature of the calender rolls
15   to form a prebonded nonwoven spunbond filament layer; [[b')]]
16   treating the prebonded nonwoven spunbond filament layer
17   with at least one wetting agent; [[c)]]
18   applying at least one layer of hydrophilic fibers onto
19   the prebonded nonwoven spunbond filament layer treated with the
20   wetting agent; and   [[d)]]

21   hydrodynamically bonding the layer of hydrophilic fibers

22 to the spunbond filament layer to create a two-layer laminate

23 forming an absorbent cloth.

1   19. (previously presented) The method defined in claim

2   18 wherein the nonwoven spunbond filament layer is prebonded in

3   step b) in a calender.

1   20. (previously presented) The method defined in claim

2   19 wherein the nonwoven spunbond filament layer is prebonded in

3   step b) in a calender having at least one heated embossing drum

4   cylinder.

1   21. (previously presented) The method defined in claim

2   20 wherein the prebonding is carried out in step b) such that a

3   maximum free filament length between two bonding points of the

4   nonwoven spunbond layer is less than 15 mm.

1   22. (previously presented) The method defined in claim

2   21, further comprising the step of additionally deforming the

3   prebonded nonwoven spunbond filament layer to increase the

4   thickness thereof.

1   23. (previously presented) The method defined in claim

2   22 wherein the hydrophilic fibers are applied by at least one

22882AM6.WPD

3   carding machine or at least one air-layering device onto the

4   prebonded nonwoven spunbond filament layer.

1   24.   (previously presented)   The method defined in claim

2   23, further comprising the step of applying a second spunbond

3   nonwoven material onto the laminate formed by the layers.

1   25.   (previously presented)   The method defined in claim

2   24 wherein the hydrodynamic bonding of the layers into the laminate

3   is effected by a water-jet treatment thereof.

1   26.   (previously presented)   The method defined in claim

2   18 wherein the prebonding is carried out in step b) such that a

3   maximum free filament length between two bonding points of the

4   nonwoven spunbond layer is less than 15 mm.

1   27.   (previously presented)   The method defined in claim

2   18, further comprising the step of additionally deforming the

3   prebonded nonwoven spunbond filament layer to increase the

4   thickness thereof.

1   28.   (previously presented)   The method defined in claim

2   18 wherein the wetting agent is at least one tenside or surface

3   active agent.

22882AM6.WPD

1   29. (previously presented) The method defined in claim

2   18 wherein the hydrophilic fibers are applied by at least one

3   carding machine or at least one air-layering device onto the

4   prebonded nonwoven spunbond filament layer.

1   30. (previously presented) The method defined in claim

2   18, further comprising the step of applying a second spunbond

3   nonwoven material onto the laminate formed by the layers.

1   31. (previously presented) The method defined in claim

2   18 wherein the hydrodynamic bonding of the layers into the laminate

3   is effected by a water-jet treatment thereof.

1   32. (new) A method of making a fiber laminate, the

2   method comprising the steps of sequentially:

3   a) forming a nonwoven spunbond filament layer;

4   b) prebonding the nonwoven spunbond filament layer to a

5   tensile strength of at least 50% of the tensile strength thereof at

6   maximum bonding as defined in DIN 53815 to form a prebonded

7   nonwoven spunbond filament layer such that a maximum free path

8   length between two bonding points of the spunbond filaments is less

9   than 15 mm;

10   c) treating the prebonded nonwoven spunbond filament

11   layer with at least one wetting agent;

12   d) applying at least one layer of hydrophilic fibers onto

13   the prebonded nonwoven spunbond filament layer treated with the

14   wetting agent; and

15   e) hydrodynamically bonding the layer of hydrophilic

16   fibers to the spunbond filament layer to create a two-layer

17   laminate forming an absorbent cloth.

22882AM6.WPD

1   33.   (new)   A method of making a fiber laminate, the

2   method comprising the steps of sequentially:

3   a) forming a nonwoven spunbond filament layer;

4   b) prebonding the nonwoven spunbond filament layer to a

5   tensile strength of at least 50% of the tensile strength thereof at

6   maximum bonding as defined in DIN 53815 to form a prebonded

7   nonwoven spunbond filament layer;

8   c) deforming the prebonded spunbond filament layer so as

9   to increase its thickness;

10   d) treating the prebonded nonwoven spunbond filament

11   layer with at least one wetting agent;

12   e) applying at least one layer of hydrophilic fibers onto

13   the prebonded nonwoven spunbond filament layer treated with the

14   wetting agent; and

15   f) hydrodynamically bonding the layer of hydrophilic

16   fibers to the spunbond filament layer to create a two-layer

17   laminate forming an absorbent cloth.

22882AM6.WPD

1   34.   (new)   A method of making a fiber laminate, the

2   method comprising the steps of sequentially:

3   a) forming a nonwoven spunbond filament layer;

4   b) prebonding the nonwoven spunbond filament layer to a

5   tensile strength of at least 50% of the tensile strength thereof at

6   maximum bonding as defined in DIN 53815 to form a prebonded

7   nonwoven spunbond filament layer such that a maximum free path

8   length between two bonding points of the spunbond filaments is less

9   than 15 mm;

10   c) deforming the prebonded spunbond filament layer so as

11   to increase its thickness;

12   d) treating the thickness-increased prebonded nonwoven

13   spunbond filament layer with at least one wetting agent;

14   e) applying at least one layer of hydrophilic fibers onto

15   the prebonded nonwoven spunbond filament layer treated with the

16   wetting agent; and

17   f) hydrodynamically bonding the layer of hydrophilic

18   fibers to the spunbond filament layer to create a two-layer

19   laminate forming an absorbent cloth.

22882AM6.WPD